4-49



| DART AEROSPACE LTD | Work Order: | 21788 |
|--------------------------|--------------|-------------|
| Description: Bracket | Part Number: | D3207-3 |
| Dwg: D3207 Rev. A | Qty: | 9 4 |
| d | | Page 1 of 1 |

| Step | Location | Procedure | Ву | Date | Qty | |
|------|----------|---|---------------|----------|--------|-----------|
| 1 | DC | Issue Traveler | 111 | | | |
| | | Note: To be made in multiples of 5. | 9XH | 04.10.25 | 4 | |
| | | Dwg not required | 1, 0 | ,,, | | ¥ |
| 2 | MV | Cut blank: 3.69" x 5.51" (+0.020/-0.000) grain along 5.510" | | | | · |
| | | Material: 6061-T6 (QQ-A-250/11) 0.125" thick | | | | |
| • | | (M6061T6S.125) | m | 1.1.1 | 10 | |
| | | Identify for D3207-3 Batch: 915120 | - MY | 84/11/01 | 10 | |
| 3 | MV . | Machine D3207-3 as per Folio FA396 and Dwg D3207 | | | | • |
| | | Stack of 5 | 8 | ~ 1 1 - | | -9 Pho |
| | | Identify as D3207-3 | 14 | C4/11/22 | 40 | 1 9 10 |
| 4 | QC2 | Inspect parts as they come off the CNC machine | 50 | allilor | جهد | 3 |
| 5 | QC8 | Second check | 0 | <u> </u> | | • |
| J | QCo | Second check | 12 | 01.11.02 | 4 | |
| . 6 | GA | Deburr Stack | 0- | | 0 | |
| | | | 13E | 04-11-12 | 7_ | |
| 7 | GB | Form as per Dwg D3207 | 9 | 04.12.14 | 5 | |
| 8 | QC5 | Inspect work to Step 7 | | outalia | a | |
| | | | JAN . | 04/12/16 | 7 | |
| 9 | FP | Chemical conversion Coat as per QSI 005 4.1 | IU | 04-12-16 | 9 | * |
| 10 | FP | Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 | Just | | D | 7. pag. 4 |
| | | | | 0112 20 | 7 | - 1 |
| . 11 | QC3 | Inspect Powder Coat | 44 | S. L 131 | 9 | |
| | | | <u> </u> | 0/115/91 | | |
| 12 | ST | Identify and Stock | cd | 04115151 | 9 | 11. |
| 13 | AC | | | | | |
| | 3, | Cost / part/23,29 | 290 | ag-01-03 | _ کے ا | |
| 14 | DC | Close W/O Z 3. Z 7 | da | 05.01.06 | 9 | |
| L | L | Inspect Level 21 | ~ M X/ | | | |
| Rev | Date | Change | Revisěd | By Appr | oved | |

RevDateChangeRevised ByApprovedA04.06.09New issueKJ/RF

RELEASED

DE 34, 36.21

Dart Aerospace Ltd

| W/O: WORK ORDER CHANGES | | | | | | | |
|-------------------------|------|------------------|--|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|----------|------|---|----------------|-----------------------------|----------------|--------------|------------|--------------|--|
| | | Description of NC | | Corrective Action Section B | | Verification | Approval | Approval | |
| DATE | STEP | Section A | | | Sign & Daţe | Section C | Design Mgr | QC Inspector | |
| C4.11 to | 3 | one scrap - test piece Ser bondines | R per (STH) | destrey | Baillos | on les | per GiI 49 | 04.1102 | |
| | | | • | | | | | | |
| | | | | · | | | | | |

| Part No: <u>D3207-3</u> | PAR #: | Fault Category: | NCR: | Yes (No) DQA: | Date: <u>65.61.06</u> | |
|----------------------------------|--------|-----------------|------|-----------------|-----------------------|--|
| NOTE: Date & initial all entries | | 4. | | QA: N/C Closed: | Date: | |

Job Costing Report

| Dart | Aerospace | Ltd. |
|-------|-----------|------|
| Hawke | esburv | |

Oct 21, 2004 03:29 pm

Work Order No : 0021788
Project Name : D3207-3

Project Name : D3207-3
Project For : WK449
Work Order Type : Main

Main WO Number :

House Part Number: D3207-3
Description: Bracket

Manufactured : Yes Amount Req'd :

Amount Done : 0
Start Date : 10-21-04

Est Finish Date : 11-30-04

Act Finish Date : Drawings Reqd : No Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount: 0.00

Order Entry No :

OE Value : 0.00

Est Margin : 0.000% Actual Margin : 0.000%

\$0 Posted to Finished Goods

| | | Estimated | Actual | Var. % | Posted | To Post |
|---------------------------------------|----------|-----------|--------------|--------------|--------|---------|
| Material Cost | === : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours Engineering Cost | : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours Production Cost | : | 0.00 | 0.00 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours Packaging Cost | : | 0.00 | 0.00 0.00 | 0.00 0.00 | 0.00 | 0.00 |
| OverHead Hours OverHead Cost | : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours CNC | : | 0.00 | 0.00 | 0.00 0.00 | 0.00 | 0.00 |
| Misc. Hours | : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden | • | 0.00 | 0.00 | 0.00 | | |
| • | • | 0.00 | 0.00 | 0.00 | • | |
| Total Cost Margin | : | 0.000 | 0.000 | 0.00 | | |
| Selling Cost | : | 0.00 | 0.00 | | | |

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) : 0.00 0.00

| DART AEROSPACE LTD | Work Order: | 21788 |
|-------------------------------|--------------|-------------|
| Description: BRAULET | Part Number: | D3707-3 |
| Inspection Dwg: D3 707 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|---------------|---------------------|--------|--------|--|----------|
| 0.800 | 1-0.016 | 0.796 | _ | · | Height go | ize |
| 4.000 | 1 0.010 | 4.003 | | | vers | |
| \$0.438 | 10005 | 0.440 | · | | vern | |
| 2 0.50 | きのつろの | 0.50 | | | 8.4 | |
| 3.712 | + 0.010 | 3.707 | | | Hashtya | e . |
| R 0.75 | ±0.030 | 0.25 | | | 12.9 | |
| 2.000 | ±0010 | 2.001 | _ | | Height you | ne |
| 37° | + 1/20 | 37° | | | Bevel Proct | actor |
| 1.53 | + 0.030 | 1,531 | \ | | Height you | ue |
| 4.212 | - 0010 | 4.709 | | | Hosht you | ge. |
| 0.125 | + 0.010 | 0.175 | | | \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ | : |
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|--------------|----------|-------------|---------|---------------------|----------|
| Measured by: | En | Audited by: | my | Prototype Approval: | a |
| Date: | 04/10/02 | Date: | 04/1/02 | Date: | 04.11.02 |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| Α | ' | New Issue | KJ/JLM | • |